Vietz®

Pipeline Equipment

Plastic Welding Equipment

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VIETZ MANUAL Butt Welding Machines

VIETZ MANUAL Butt Welding Machines

The VIETZ MANUAL series comprises manually operated butt welding machines for welding pipes made from PE, PP and PVDF. The machines are available in seven sizes, allowing to weld all pipe dimensions from OD 40 mm to OD 800 mm. Standard supply includes the basic machine and a hydraulic control unit, as well as a facer and a heating plate plus a portable tool holder for comfortable handling of the tools. A complete set of reduction inserts allows to use the machines for all nominal diameters.

All machines of the VIETZ MANUAL series offer reliable and complete recording and documentation of welding and traceability data by means of the data-logging system VIETZ SPG-2000 or SPG-2000-Basic, respectively, which is connected to the hydraulic control unit. The data recorded by the system can be sent to a PC, laptop, pocket PC or the integrated micro printer (only SPG-2000) by means of the data management software DataWork.

VIETZ MANUAL series

	EV 160H Manual	EV 200H Manual	EV 250H Manual	EV 315H Manual	EV 500H Manual	EV 630H Manual	EV 800H Manual
Working range	40 - 160 mm	63 - 200 mm	75 - 250 mm	90 - 315 mm	200 - 500 mm	355 - 630 mm	500 - 800 mm
Hydraulic unit	•	•	•	•	•	•	•
Basic machine (pipe rack assembly)	•	•	•	•	•	•	•
Facer with micro safety switch	•	•	•	•	•	•	•
Heating plate with non-stick PTFE coating	•	•	•	•	•	•	•
Electric crane (option) for facer and heating plate					•	•	•
Portable tool holder for facer and heating plate	•	•	•	•	•	•	•
Storage case	•	•	•	•	•	•	•
Power supply	230 V, 50 Hz, 1 P	230 V, 50 Hz, 1 P	230 V, 50 Hz, 1 P	230 V, 50 Hz, 1 P	400 V, 50 Hz, 3 P	400 V, 50 Hz, 3 P	400 V, 50 Hz, 3 P
Output power	1,85 kW	2,05 kW	3,14 kW	4,14 kW	7,6 kW	10,7 kW	15,44 kW
Reduction inserts	40, 50, 63, 75, 90, 110, 125, 140 mm, stub-end holder	63, 75, 90, 110, 125, 140, 160, 180 mm, stub-end holder	75, 90, 110, 125, 140, 160, 180, 200, 225 mm, stub-end holder	90, 110 125, 140, 160, 180, 200, 225, 250, 280 mm, stub-end holder	200, 225, 250, 280, 315 355, 400, 450 mm, stub-end holder	355, 400, 450, 500, 560 mm, stub-end holderr	500, 560, 630, 710 mm, stub-end holder
Designed for upgrade with SPG data-logging system	•	•	•	•	•	•	•

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VIETZ Butt Welding Machine EV 160H MANUAL

Butt welding machine for welding pipes and fittings made of PE, PP and PVDF.
Working range: OD 40 - OD 160 mm (for all pressure stages)

VIETZ EV 160H MANUAL

Components	kg	Item-No.:
Hydraulic unit, 230 V, 400 W	28,3	45510
Basic machine (pipe rack assembly) OD 40 - OD 160 mm	27,0	45511
Facer, 230 V, 450 W	7,5	45512
Heating plate (adjustable), 230 V, 1000 W	3,6	45513
Portable tool holder	3,5	45514
Storage case	40,0	45515
Complete machine	**110,0**	**45500**

Stopwatch

Necessary for use without Data-Logging-System

reverse running • with signal • incl. magnet	**Item-No.: 70789**

Accessories

	Item-No.:
Stub-end holder	**45516**

Reduction inserts, extra wide

Size	Item-No.:
OD 40	45701
OD 50	45702
OD 63	45703
OD 75	45704
OD 90	45705
OD 110	45706
OD 125	45707
OD 140	45708
Complete set of reduction inserts (OD 40 - OD 140)	**45700**
Special inserts for irregular dimensions	45709

Spare parts

	Item-No.:
Hydraulic oil 1 l	**70195**
Blade for facer for EV 160H	**45517**

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VIETZ Butt Welding Machine EV 200H MANUAL

Butt welding machine for welding pipes and fittings made of PE, PP and PVDF.
Working range: OD 63 - OD 200 mm (for all pressure stages)

VIETZ EV 200H MANUAL

Components	kg	Item-No.:
Hydraulic unit, 230 V, 400 W	28,3	45520
Basic machine (pipe rack assembly) OD 63 - OD 200 mm	22,0	45521
Facer, 230 V, 650 W	6,3	45522
Heating plate (adjustable), 230 V, 1000 W	4,0	45523
Portable tool holder	4,4	45524
Storage case	40,0	45515
Complete machine	**105,0**	**45501**

Stopwatch

Necessary for use without Data-Logging-System

reverse running • with signal • incl. magnet **Item-No.: 70789**

Accessories

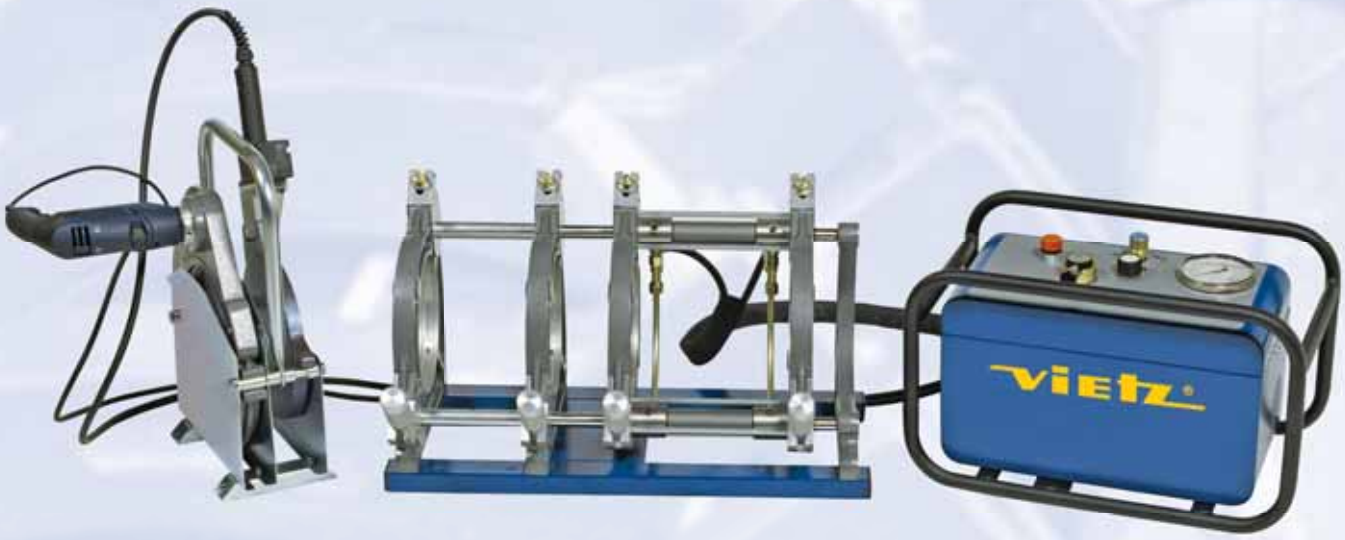
	Item-No.:
Stub-end holder	**45526**

Reduction inserts, extra wide

Size	Item-No.:
OD 63	45711
OD 75	45712
OD 90	45713
OD 110	45714
OD 125	45715
OD 140	45716
OD 160	45717
OD 180	45718
Complete set of reduction inserts (OD 63 - OD 180)	**45710**
Special inserts for irregular dimensions	45709

Spare parts

	Item-No.:
Hydraulic oil 1 l	**70195**
Blade for facer for EV 200H	**45527**



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VIETZ Butt Welding Machine EV 250H MANUAL

Butt welding machine for welding pipes and fittings made of PE, PP and PVDF.
Working range: OD 75 - OD 250 mm (for all pressure stages)

VIETZ EV 250H MANUAL

Components	kg	Item-No.:
Hydraulic unit, 230 V, 400 W	28,3	45530
Basic machine (pipe rack assembly) OD 75 - OD 250 mm	54,0	45531
Facer, 230 V, 740 W	15,0	45532
Heating plate (adjustable), 230 V, 2000 W	8,0	45533
Portable tool holder	3,5	45534
Storage case	40,0	45535
Complete machine	**148,0**	**45502**

Stopwatch

Necessary for use without Data-Logging-System

reverse running • with signal • incl. magnet **Item-No.: 70789**

Reduction inserts, extra wide

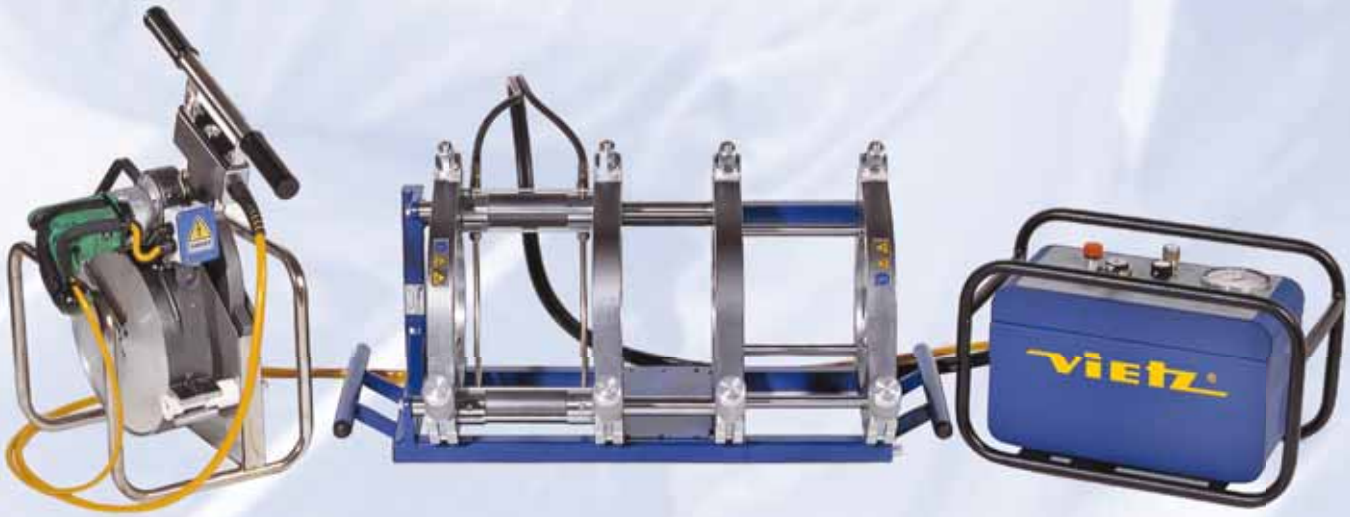
Size	Item-No.:
OD 75	45721
OD 90	45722
OD 110	45723
OD 125	45724
OD 140	45725
OD 160	45726
OD 180	45727
OD 200	45728
OD 225	45729
Complete set of reduction inserts (OD 75 - OD 225)	**45720**
Special inserts for irregular dimensions	45709

Accessories

	Item-No.:
Stub-end holder	45536

Spare parts

	Item-No.:
Hydraulic oil 1 l	70195
Blade for facer for EV 250H	45537



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VIETZ Butt Welding Machine EV 315H MANUAL

Butt welding machine for welding pipes and fittings made of PE, PP and PVDF.
Working range: OD 90 - OD 315 mm (for all pressure stages)

VIETZ EV 315H MANUAL

Components	kg	Item-No.:
Hydraulic unit, 230 V, 400 W	28,3	45540
Basic machine (pipe rack assembly) OD 90 - OD 315 mm	100,0	45541
Facer, 230 V, 740 W	21,0	45542
Heating plate (adjustable), 230 V, 2500 W	13,0	45543
Portable tool holder	16,0	45544
Storage case	50,0	45535
Complete machine	**228,0**	**45503**

Stopwatch

Necessary for use without Data-Logging-System

reverse running • with signal • incl. magnet **Item-No.: 70789**

Accessories

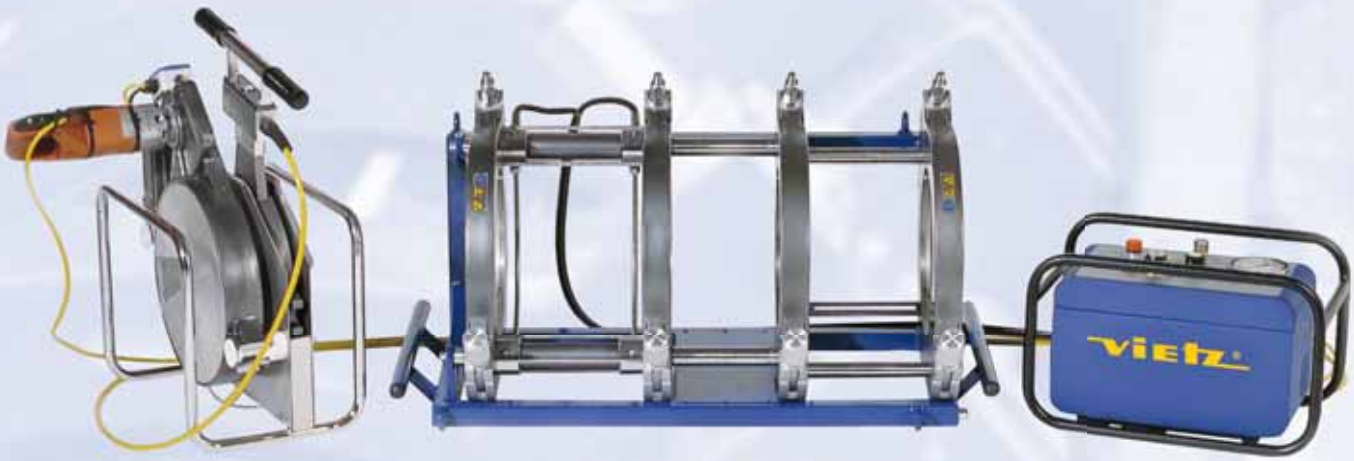
	Item-No.:
Stub-end holder	**45546**

Reduction inserts, extra wide

Size	Item-No.:
OD 90	45731
OD 110	45732
OD 125	45733
OD 140	45734
OD 160	45735
OD 180	45736
OD 200	45737
OD 225	45738
OD 250	45739
OD 280	45739A
Complete set of reduction inserts (OD 90 - OD 280)	**45730**
Special inserts for irregular dimensions	45709

Spare parts

	Item-No.:
Hydraulic oil 1 l	**70195**
Blade for facer for EV 250H	**45547**



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VIETZ Butt Welding Machine EV 500H MANUAL

Butt welding machine for welding pipes and fittings made of PE, PP and PVDF.
Working range: OD 200 - OD 500 mm (for all pressure stages)

VIETZ EV 500H MANUAL

Components	kg	Item-No.:
Hydraulic unit, 230 V, 800 W	35,0	45550
Basic machine (pipe rack assembly) OD 200 - OD 500 mm	197,0	45551
Facer, 400 V, 1825 W	62,0	45552
Heating plate (adjustable), 400 V, 5000 W	25,0	45553
Portable tool holder	30,0	45554
Storage case	80,0	45555
Complete machine	**429**	**45504**

Stopwatch

Necessary for use without Data-Logging-System

reverse running • with signal • incl. magnet	**Item-No.: 70789**

Accessories

	Item-No.:
Stub-end holder	**45556**

Reduction inserts, extra wide

Size	Item-No.:
OD 200	45741
OD 225	45742
OD 250	45743
OD 280	45744
OD 315	45745
OD 355	45746
OD 400	45747
OD 450	45748
Complete set of reduction inserts (OD 200 - OD 450)	**45740**
Special inserts for irregular dimensions	45749

Spare parts

	Item-No.:
Hydraulic oil 1 l	**70195**
Blade for facer for EV 500H	**45557**

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VIETZ Butt Welding Machine EV 630H MANUAL

Butt welding machine for welding pipes and fittings made of PE, PP and PVDF.
Working range: OD 355 - OD 630 mm (for all pressure stages)

VIETZ EV 630H MANUAL

Components	kg	Item-No.:
Hydraulic unit, 400 V, 1300 W	35,0	45560
Basic machine (pipe rack assembly) OD 355 - OD 630 mm	297,0	45561
Facer, 400 V, 1840 W	143,0	45562
Heating plate (adjustable), 400 V, 8100 W	43,0	45563
Portable tool holder	10,0	45564
Storage case	90,0	45565
Complete machine	**429**	**45505**

Reduction inserts, extra wide

Size	Item-No.:
OD 355	45751
OD 400	45752
OD 450	45753
OD 500	45754
OD 560	45755
Complete set of reduction inserts (OD 355 - OD 560)	**45750**
Special inserts for irregular dimensions	45749

Stopwatch

Necessary for use without Data-Logging-System

reverse running • with signal • incl. magnet	**Item-No.: 70789**

Spare parts

	Item-No.:
Hydraulic oil 1 l	**70195**
Blade for facer for EV 630H	**45568**

Accessories

	Item-No.:
Stub-end holder	**45566**
Electric crane	**45567**

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VIETZ Butt Welding Machine EV 800H MANUAL

Butt welding machine for welding pipes and fittings made of PE, PP and PVDF.
Working range: OD 500 - OD 800 mm (for all pressure stages)

VIETZ EV 800H MANUAL

Components	kg	Item-No.:
Hydraulic unit, 400 V, 1300 W	40,0	45570
Basic machine (pipe rack assembly) OD 500 - OD 800 mm	740,0	45571
Facer, 400 V, 2944 W	220,0	45572
Heating plate (adjustable), 400 V, 12000 W	60,0	45573
Portable tool holder	11,0	45574
Storage case	90,0	45575
Complete machine	**1161**	**45506**

Reduction inserts, extra wide

Size	Item-No.:
OD 500	45761
OD 560	45762
OD 630	45763
OD 710	45764
Complete set of reduction inserts (OD 500 - OD 710)	**45760**
Special inserts for irregular dimensions	45749

Stopwatch

Necessary for use without Data-Logging-System

reverse running • with signal • incl. magnet Item-No.: **70789**

Spare parts

	Item-No.:
Hydraulic oil 1 l	**70195**
Blade for facer for EV 800H	**45578**

Accessories

	Item-No.:
Stub-end holder	**45576**
Electric crane	**45577**

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VIETZ Data-Logging System SPG-2000-Basic

VIETZ Data-Logging System SPG-2000-Basic

The VIETZ Data-Logging System SPG-2000-Basic allows to record welding data quickly and accurately and to save these data as welding reports according to DVS (German Welding Society) or other internationally applicable standards. This system is particularly designed to work with the VIETZ butt welding machines of the Manual series, however, it can be used also in connection with hydraulic-driven butt welding machines of other manufacturers.

SPG-2000-Basic allows to record all data relevant for weld quality assessment, and to send them to a PC, laptop, pocket PC by means of the data management software DataWork.

Advantages at a glance

- easy to use due to user-friendly menu structure,
- menus and reports available in various languages,
- sealed alphanumeric keypad with welding process diagram,
- PC interface (RS232), printer (Centronics),
- allows to record 1000 welding operations,
- LED display with 4 lines, 20 characters each,
- self-test after power-on,
- customizable data-logging function,
- pressure sensors 100 bar or 250 bar, as requested,
- various temperature sensors,
- welding progress displayed by LEDs,
- bar-code scanning wand

Monitoring functions

- build-up pressure,
- heating-plate temperature,
- heat soaking pressure,
- heat soaking time,
- ramp,
- joining pressure,
- cooling time,
- power supply failure,
- ambient temperature,
- report memory.

Traceability

- pipe code (max. 40 characters, ISO),
- fitting code (26 characters, ISO),
- weather (DVS),
- additional data (max. 20 characters).

Data recording

- machine type and ID,
- cylinder data,
- sensors data,
- material data,
- diameter, wall thickness, nominal pressure,
- angle data,
- consecutive number and weld number,
- commission number (max. 32 digits),
- welder's ID (ISO),
- date and time,
- ambient temperature,
- actual values and setpoints of drag pressure, mirror temperature (can be disabled), build-up pressure/time, heat soaking pressure/time, changeover delay, joining pressure ramp, joining pressure, cooling time

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VIETZ Data-Logging System SPG-2000-Basic

VIETZ-SPG-2000-Basic

• monitoring • data recording • traceability

Item-No.: 45581

Accessories

Components	Item-No.:
Storage case	45582
Pressure sensor 100 bar	45583
Pressure sensor 250 bar	45584
T-piece	45585
Changeover for external machines	45587
Temperature sensor PT100	45588
Pressure-sensor cable	45589
Temperature-sensor cable	45590
Welder's ID / Operator code	45591
DataWork GIS, database software	42256
EasyDesign, bar-code and job-report generation software	45592
Pocket PC	42255P
DataTrans, pocket PC software	42255
USB adaptor	42255U

Technical specifications:

Input voltage:	100 V - 260 V
Input frequency:	40 Hz - 80 Hz
Enclosure:	IP 54
Dimensions:	240 x 200 x 125 mm
Weight:	4 kg

Please contact our sales staff to check whether your butt welding machine is pre-equipped for the VIETZ SPG system and what accessories you require.

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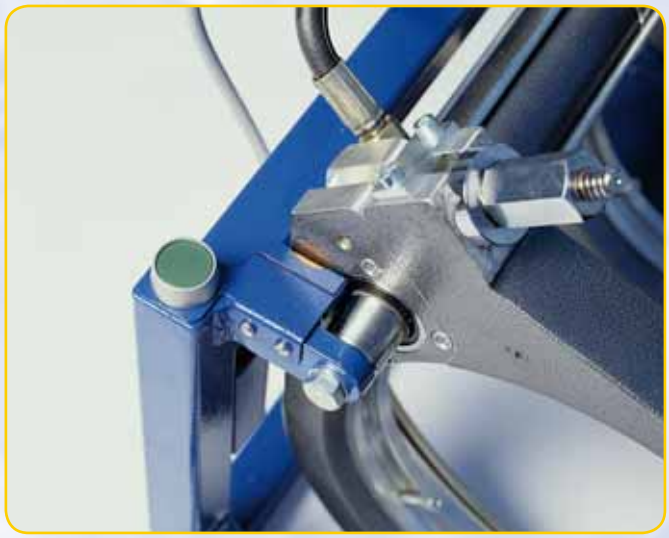
VIETZ CNC-ECO Butt Welding Machines

VIETZ CNC-ECO Butt Welding Machines

The VIETZ CNC-ECO series comprises CNC-controlled butt welding machines for welding pipes and fittings made of PE, PP and PVDF. The machines are available in seven sizes, allowing to weld all pipe dimensions from OD 40 mm to OD 800 mm. Standard supply includes the basic machine incl. machine-control push-button, a CNC unit, a facer with safety switch, a heating plate with anti-stick coating, a portable tool holder and a storage case. A complete set of reduction inserts allows to use the machines for all nominal diameters.

Extremely user-friendly menus allow to select workpiece traceability data as well as data concerning material, diameter, wall thickness or pressure stages. The welding process is then automatically executed, monitored and documented in the internal memory.

It is possible to transfer welding reports to a PC by means of the DataWork database and data management program DataWork, or to print out reports with a usual printer. DataWork allows also transfer and management of welding reports generated by the VIETZ HST-300 Electrofusion Welding Machines.



Technical specifications:

- **Machine-control push-button**
  Allows not only to manipulate the basic machine, but also to confirm various working steps, such as facing or edge alignment control.
- **Calculation of all welding times and pressures with duplicate graphic representation**
  Graphic representation both on the large, back-lit display and by means of the progress-indicating LEDs in the welding diagram.
- **Automatic control**
  Of the heating-plate temperature according to pipe specifications.
- **Integrated welding process monitoring system**
  Continuously records actual values of welding pressure, welding times, conversion times, heating-plate temperature and possible power failure.
- **Automatic measurement of ambient temperature**
- **Data memory for up to 1500 welding reports**
  Reports can be transfered to PC, printer or external memory via parallel, serial or USB interface.
- **Welding process control according to national standards**
  Adjustable to the standard you prefer: DVS, INSTA, WIS, UNI etc. More national standards available on request.
- **Traceability**
  According to latest standards.
- **Bar-code scanning wand**
  For error-free entry of bar codes of pipes, fittings and welders.
- **Alphanumeric keyboard**
  For user-friendly data input.
- **Multi-lingual user navigation**
  German, English, French, Russian, Portuguese, Spanish, Finnish (other languages available on request).

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VIETZ CNC-ECO Butt Welding Machines

VIETZ CNC-ECO series

	EV 160H CNC-ECO	EV 200H CNC-ECO	EV 250H CNC-ECO	EV 315H CNC-ECO	EV 500H CNC-ECO	EV 630H CNC-ECO	EV 800H CNC-ECO
Working range	40 - 160 mm	63 - 200 mm	75 - 250 mm	90 - 315 mm	200 - 500 mm	355 - 630 mm	500 - 800 mm
CNC unit	•	•	•	•	•	•	•
Basic machine (pipe rack assembly) incl. machine-control push-button	•	•	•	•	•	•	•
Facer with micro safety switch	•	•	•	•	•	•	•
Heating plate with non-stick PTFE coating	•	•	•	•	•	•	•
Electric crane (option) for facer and heating plate					•	•	•
Portable tool holder for facer and heating plate	•	•	•	•	•	•	•
Storage case	•	•	•	•	•	•	•
Power supply	230 V, 50 Hz, 1 P	230 V, 50 Hz, 1 P	230 V, 50 Hz, 1 P	230 V, 50 Hz, 1 P	400 V, 50 Hz, 3 P	400 V, 50 Hz, 3 P	400 V, 50 Hz, 3 P
Output power	2,25 kW	2,45 kW	3,54 kW	4,54 kW	8,4 kW	11,5 kW	16,24 kW
Reduction inserts	40, 50, 63, 75, 90, 110, 125, 140 mm, stub-end holder	63, 75, 90, 110, 125, 140, 160, 180 mm, stub-end holder	75, 90, 110, 125, 140, 160, 180, 200, 225 mm, stub-end holder	90, 110 125, 140, 160, 180, 200, 225, 250, 280 mm, stub-end holder	200, 225, 250, 280, 315 355, 400, 450 mm, stub-end holder	355, 400, 450, 500, 560 mm, stub-end holder	500, 560, 630, 710 mm, stub-end holder

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VIETZ Butt Welding Machine EV 160H CNC-ECO

CNC-controlled butt welding machine for welding pipes and fittings made of PE, PP and PVDF.
Working range: OD 40 - OD 160 mm (for all pressure stages)

		EV 160H CNC-ECO+ • Data logging according to ISO (1500 welding processes) • Bar-code scanning wand • Path measurement • Welding with ISO pipe codes	EV 160H CNC-ECO • Data logging (1000 welding processes) • Bar-code scanning wand
Component	**kg**	**Item-No.:**	**Item-No.:**
CNC unit 230 V, 800 W	38,0	45615	45620
Basic machine (pipe rack assembly) OD 40 - OD 160 mm	27,0	45616	45621
Facer, 230 V, 450 W	7,5	45512	45512
Heating plate, 230 V, 1000 W	3,6	45617	45617
Portable tool holder	3,5	45514	45514
Storage case	40,0	45515	45515
Complete machine	**125,0**	**45600**	**45601**

Reduction inserts, extra wide

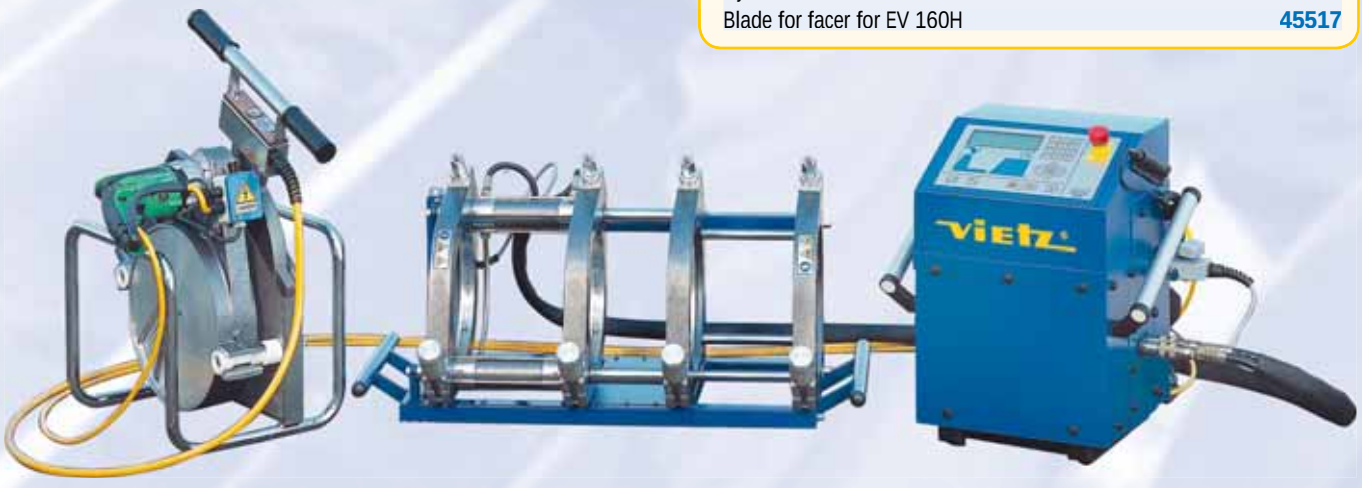
Size	Item-No.:
OD 40	45701
OD 50	45702
OD 63	45703
OD 75	45704
OD 90	45705
OD 110	45706
OD 125	45707
OD 140	45708
Complete set of reduction inserts (OD 40 - OD 140)	**45700**
Special inserts for irregular dimensions	45709

Accessories / Options

Component	Item-No.:
Automatic ejection of heating plate	**45618**
Stub-end holder	**45516**
Welder ID / Operator code	**45591**
DataWork GIS, database software	**42256**
EasyDesign, bar-code and job-report generation software	**45592**
Pocket PC	**42255P**
DataTrans, pocket PC software	**42255**

Spare parts

Component	Item-No.:
Hydraulic oil 1 l	**70195**
Blade for facer for EV 160H	**45517**



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VIETZ Butt Welding Machine EV 200H CNC-ECO

CNC-controlled butt welding machine for welding pipes and fittings made of PE, PP and PVDF.
Working range: OD 63 - DA 200 mm (for all pressure stages)

		EV 200H CNC-ECO+ • Data logging according to ISO (1500 welding processes) • Bar-code scanning wand • Path measurement • Welding with ISO pipe codes	EV 200H CNC-ECO • Data logging (1000 welding processes) • Bar-code scanning wand
Component	**kg**	**Item-No.:**	**Item-No.:**
CNC unit 230 V, 800 W	38,0	45630	45633
Basic machine (pipe rack assembly) OD 63 - OD 200 mm	22,0	45631	45634
Facer, 230 V, 650 W	6,3	45522	45522
Heating plate, 230 V, 1000 W	4,0	45632	45632
Portable tool holder	4,4	45524	45524
Storage case	40,0	45515	45515
Complete machine	**115,0**	**45602**	**45603**

Reduction inserts, extra wide

Size	Item-No.:
OD 63	45711
OD 75	45712
OD 90	45713
OD 110	45714
OD 125	45715
OD 140	45716
OD 160	45717
OD 180	45718
Complete set of reduction inserts (OD 63 - OD 180)	**45710**
Special inserts for irregular dimensions	45709

Accessories / Options

Component	Item-No.:
Automatic ejection of heating plate	**45635**
Stub-end holder	**45526**
Welder ID / Operator code	**45591**
DataWork GIS, database software	**42256**
EasyDesign, bar-code and job-report generation software	**45592**
Pocket PC	**42255P**
DataTrans, pocket PC software	**42255**

Spare parts

Component	Item-No.:
Hydraulic oil 1 l	**70195**
Blade for facer for EV 200H	**45527**

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VIETZ Butt Welding Machine EV 250H CNC-ECO

CNC-controlled butt welding machine for welding pipes and fittings made of PE, PP and PVDF.
Working range: OD 75 - OD 250 mm (for all pressure stages)

		EV 250H CNC-ECO+ • Data logging according to ISO (1500 welding processes) • Bar-code scanning wand • Path measurement • Welding with ISO pipe codes	EV 250H CNC-ECO • Data logging (1000 welding processes) • Bar-code scanning wand
Component	**kg**	**Item-No.:**	**Item-No.:**
CNC unit 230 V, 800 W	38,0	45640	45643
Basic machine (pipe rack assembly) OD 75 - OD 250 mm	54,0	45641	45644
Facer, 230 V, 650 W	15,0	45532	45532
Heating plate, 230 V, 1000 W	8,0	45642	45642
Portable tool holder	3,5	45534	45534
Storage case	40,0	45535	45535
Complete machine	**158,0**	**45604**	**45605**

Reduction inserts, extra wide

Size	Item-No.:
OD 75	45721
OD 90	45722
OD 110	45723
OD 125	45724
OD 140	45725
OD 160	45726
OD 180	45727
OD 200	45728
OD 225	45729
Complete set of reduction inserts (OD 75 - OD 225)	**45720**
Special inserts for irregular dimensions	45709

Accessories / Options

Component	Item-No.:
Automatic ejection of heating plate	**45645**
Stub-end holder	**45536**
Welder ID / Operator code	**45591**
DataWork GIS, database software	**42256**
EasyDesign, bar-code and job-report generation software	**45592**
Pocket PC	**42255P**
DataTrans, pocket PC software	**42255**

Spare parts

Component	Item-No.:
Hydraulic oil 1 l	**70195**
Blade for facer for EV 250H	**45537**

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VIETZ Butt Welding Machine EV 315H CNC-ECO

CNC-controlled butt welding machine for welding pipes and fittings made of PE, PP and PVDF.
Working range: OD 90 - OD 315 mm (for all pressure stages)

		EV 315H CNC-ECO+	EV 315H CNC-ECO
		• Data logging according to ISO (1500 welding processes) • Bar-code scanning wand • Path measurement • Welding with ISO pipe codes	• Data logging (1000 welding processes) • Bar-code scanning wand
Component	**kg**	**Item-No.:**	**Item-No.:**
CNC unit 230 V, 800 W	38,0	45650	45653
Basic machine (pipe rack assembly) OD 90 - OD 315 mm	100,0	45651	45654
Facer, 230 V, 650 W	21,0	45542	45542
Heating plate, 230 V, 1000 W	13,0	45652	45652
Portable tool holder	16,0	45544	45544
Storage case	50,0	45535	45535
Complete machine	**238,0**	**45606**	**45607**

Reduction inserts, extra wide

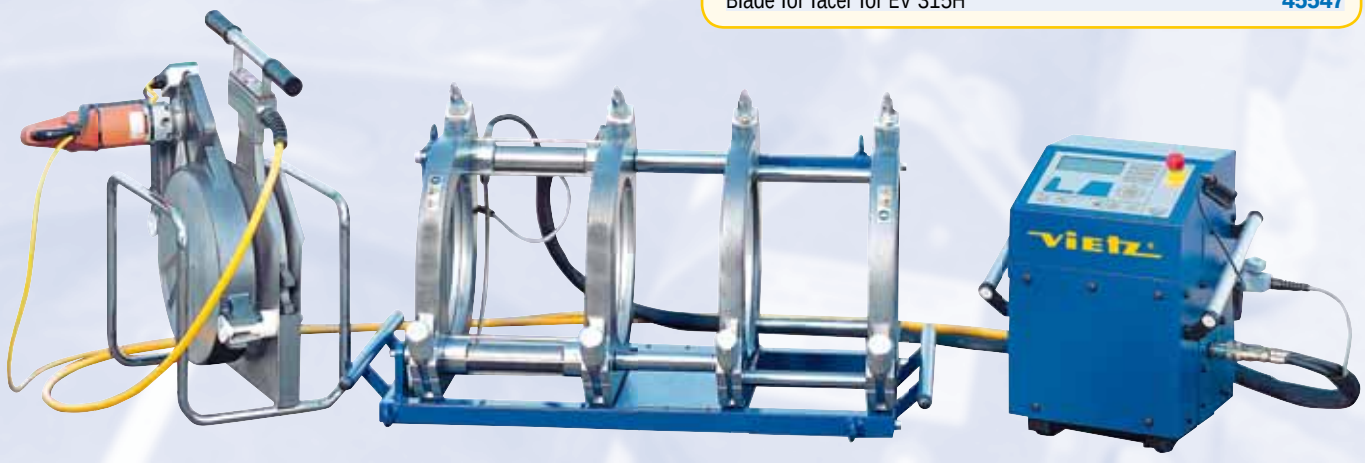
Size	Item-No.:
OD 90	45731
OD 110	45732
OD 125	45733
OD 140	45734
OD 160	45735
OD 200	45736
OD 225	45737
OD 250	45738
OD 280	45739
Complete set of reduction inserts (OD 90 - OD 280)	**45730**
Special inserts for irregular dimensions	45709

Accessories / Options

Component	Item-No.:
Automatic ejection of heating plate	**45655**
Stub-end holder	**45546**
Welder ID / Operator code	**45591**
DataWork GIS, database software	**42256**
EasyDesign, bar-code and job-report generation software	**45592**
Pocket PC	**42255P**
DataTrans, pocket PC software	**42255**

Spare parts

Component	Item-No.:
Hydraulic oil 1 l	**70195**
Blade for facer for EV 315H	**45547**



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VIETZ Butt Welding Machine EV 500H CNC-ECO

CNC-controlled butt welding machine for welding pipes and fittings made of PE, PP and PVDF.
Working range: OD 200 - OD 500 mm (for all pressure stages)

		EV 500H CNC-ECO+ • Data logging according to ISO (1500 welding processes) • Bar-code scanning wand • Path measurement • Welding with ISO pipe codes	**EV 500H CNC-ECO** • Data logging (1000 welding processes) • Bar-code scanning wand
Component	**kg**	**Item-No.:**	**Item-No.:**
CNC unit 230 V, 800 W	42,0	45660	45663
Basic machine (pipe rack assembly) OD 200 bis OD 500 mm	197,0	45661	45664
Facer, 230 V, 650 W	62,0	45552	45552
Heating plate, 230 V, 1000 W	25,0	45662	45662
Portable tool holder	30,0	45554	45554
Storage case	20,0	45555	45555
Complete machine	**436,0**	**45608**	**45609**

Reduction inserts, extra wide

Size	**Item-No.:**
OD 200	45741
OD 225	45742
OD 250	45743
OD 280	45744
OD 315	45745
OD 355	45746
OD 400	45747
OD 450	45748
Complete set of reduction inserts (OD 200 - OD 450)	**45740**
Special inserts for irregular dimensions	45749

Accessories / Options

Component	**Item-No.:**
Automatic ejection of heating plate	**45665**
Stub-end holder	**45556**
Welder ID / Operator code	**45591**
DataWork GIS, database software	**42256**
EasyDesign, bar-code and job-report generation software	**45592**
Pocket PC	**42255P**
DataTrans, pocket PC software	**42255**

Spare parts

Component	**Item-No.:**
Hydraulic oil 1 l	**70195**
Blade for facer for EV 500H	**45557**

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VIETZ Butt Welding Machine EV 630H CNC-ECO

CNC-controlled butt welding machine for welding pipes and fittings made of PE, PP and PVDF.
Working range: OD 355 - OD 630 mm (for all pressure stages)

		EV 630H CNC-ECO+ • Data logging according to ISO (1500 welding processes) • Bar-code scanning wand • Path measurement • Welding with ISO pipe codes	EV 630H CNC-ECO • Data logging (1000 welding processes) • Bar-code scanning wand
Component	**kg**	**Item-No.:**	**Item-No.:**
CNC unit 230 V, 800 W	42,0	45670	45673
Basic machine (pipe rack assembly) OD 355 bis OD 630 mm	297,0	45671	45674
Facer, 230 V, 650 W	143,0	45562	45562
Heating plate, 230 V, 1000 W	43,0	45672	45672
Portable tool holder	10,0	45564	45564
Storage case	90,0	45565	45565
Complete machine	**625,0**	**45610**	**45611**

Reduction inserts, extra wide

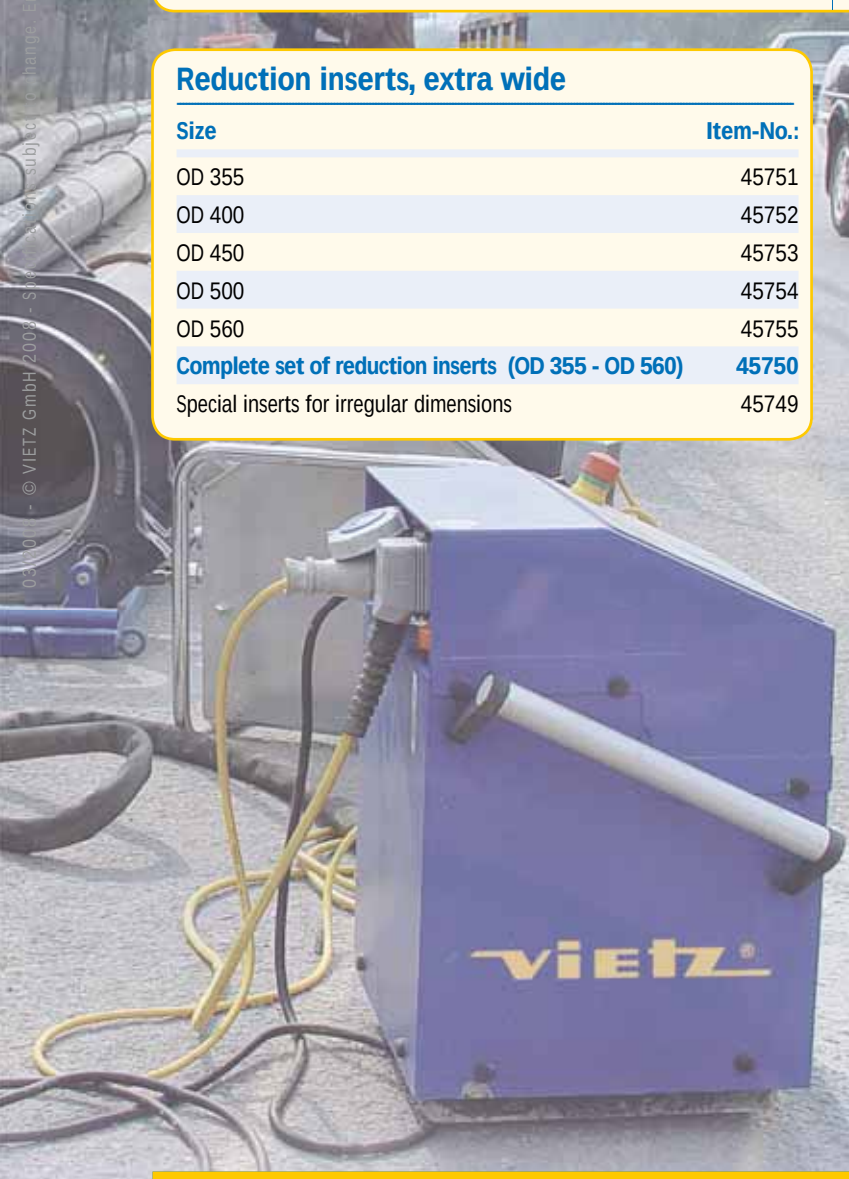
Size	Item-No.:
OD 355	45751
OD 400	45752
OD 450	45753
OD 500	45754
OD 560	45755
Complete set of reduction inserts (OD 355 - OD 560)	**45750**
Special inserts for irregular dimensions	45749

Accessories / Options

Component	Item-No.:
Automatic ejection of heating plate	**45675**
Stub-end holder	**45566**
Electric crane	**45567**
Welder ID / Operator code	**45591**
DataWork GIS, database software	**42256**
EasyDesign, bar-code and job-report generation software	**45592**
Pocket PC	**42255P**
DataTrans, pocket PC software	**42255**

Spare parts

Component	Item-No.:
Hydraulic oil 1 l	**70195**
Blade for facer for EV 630H	**45568**



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VIETZ Butt Welding Machine EV 800H CNC-ECO

CNC-controlled butt welding machine for welding pipes and fittings made of PE, PP and PVDF.
Working range: OD 500 - OD 800 mm (for all pressure stages)

		EV 800H CNC-ECO+ • Data logging according to ISO (1500 welding processes) • Bar-code scanning wand • Path measurement • Welding with ISO pipe codes	EV 800H CNC-ECO • Data logging (1000 welding processes) • Bar-code scanning wand
Component	**kg**	**Item-No.:**	**Item-No.:**
CNC unit 230 V, 800 W	42,0	45680	45683
Basic machine (pipe rack assembly) OD 500 bis OD 800 mm	740,0	45861	45684
Facer, 230 V, 650 W	220,0	45572	45572
Heating plate, 230 V, 1000 W	60,0	45682	45682
Portable tool holder	11,0	45574	45574
Storage case	90,0	45575	45575
Complete machine	**1.163,0**	**45612**	**45613**

Reduction inserts, extra wide

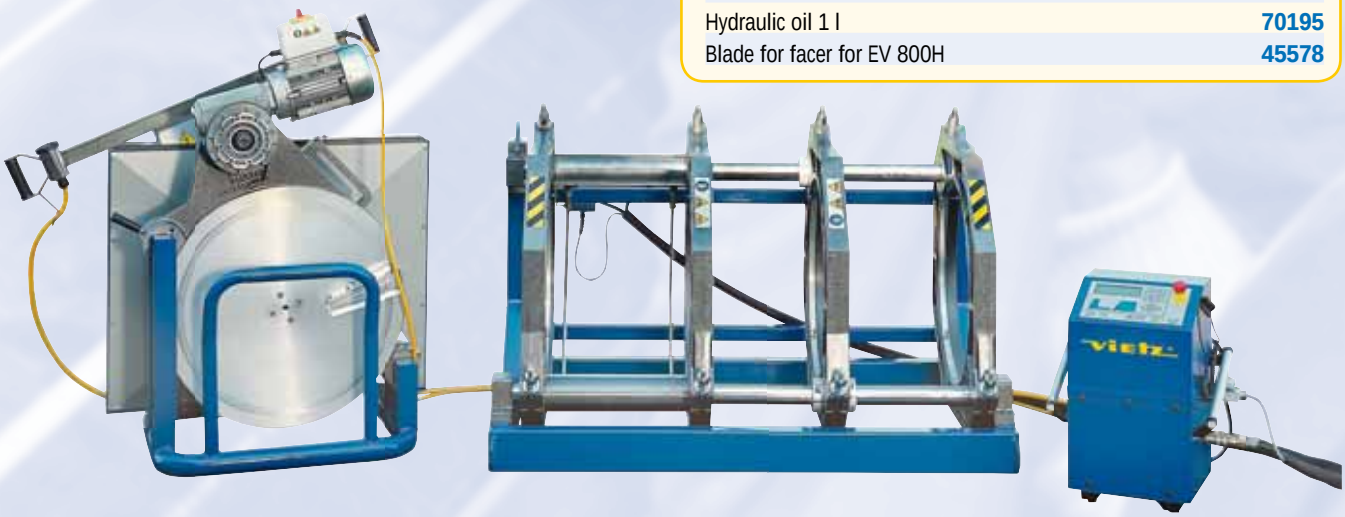
Size	Item-No.:
OD 500	45761
OD 560	45762
OD 630	45763
OD 710	45764
Complete set of reduction inserts (OD 500 - OD 710)	**45760**
Special inserts for irregular dimensions	45749

Accessories / Options

Component	Item-No.:
Automatic ejection of heating plate	**45685**
Stub-end holder	**45576**
Electric crane	**45577**
Welder ID / Operator code	**45591**
DataWork GIS, database software	**42256**
EasyDesign, bar-code and job-report generation software	**45592**
Pocket PC	**42255P**
DataTrans, pocket PC software	**42255**

Spare parts

Component	Item-No.:
Hydraulic oil 1 l	**70195**
Blade for facer for EV 800H	**45578**



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VIETZ HST 300

Electrofusion Welding Machines

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VIETZ HST 300 Electrofusion Welding Machines for welding PE, PP and PVDF pipes

VIETZ HST 300 Electrofusion Welding Machines

The HST 300 series by VIETZ offers the appropriate solution for electrofusion welding using fittings / sleeves. No matter if you choose a machine of the Junior series, the Print series or the Pricon series – all machines provide excellent welding quality also for fittings larger than 710 mm. As the machines of the HST 300 series are very lightweight and small, they can be used in practically any location.

The Pricon+ is the latest development of the HST 300 series. The machine weighs only 11 kg, while providing excellent performance like all other machines of the series. A large LED display emitting special blue light ensures user-friendly operation. The user menu can be configured individually. Data entry can be done by means of a bar-code scanning wand or manually over the alphanumeric keypad.

Extended data logging options in combination with the DataWork PC software provides new ways of uninterrupted process traceability. For example, it is possible to determine and document the exact position of the weld seam by means of a GPS receiver. Furthermore, you may enter information such as inventory numbers or the name of the pipe-installing company. Of course, the Pricon+ offers all the data logging and documentation functions known from former mod

Advantages:

- lightweight, universally applicable, particularly suitable for use on construction sites
- can be used with a power generator (generator voltage and frequency are indicated)
- audible and visible signals
- uninterrupted data logging and documentation
- 2 USB ports for fast and easy data transfer*

Scope of supply:

- VIETZ Electrofusion Welding Machine HST 300
- welding cable
- bar-code scanning wand
- operator card
- adaptor storage bag
- adaptor (round 4 mm)
- user manual
- USB-Memorystick*

*only for Print + and Pricon + versions

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VIETZ HST 300 Electrofusion Welding Machines for welding PE, PP and PVDF pipes

Technical features	HST 300 Junior	HST 300 Junior +	HST 300 Print	HST 300 Print +	HST 300 Pricon +
Item-No.:	**42250**	**42251**	**42160**	**42270**	**42271**
Bar-code scanning wand	•	•	•	•	•
Manual data entry	-	•	-	•	•
Max. number of reports	-	-	1580	1800	2000
Traceability	-	-	-	+ 1st and 2nd pipe code, 2nd fitting code	+ 1st and 2nd pipe code, 2nd fitting code
Additional data	-	-	• job number / ISO welder code • two empty fields for comments	• job number / ISO welder code • two empty fields for comments	• job number / ISO welder code • two empty fields for comments • job-number related weld number • geo data according to Gauß-Krüger • name of pipe-installing company • inventory number
Maintenance request over	display	display	display / report	display / report	display / report
Report Review	-	-	-	-	•
Interface	-	-	RS232 / Centronic	2 x USB (Front/Rear)	2 x USB (Front/Rear)
Weight	approx. 16 kg	approx. 16 kg	approx. 16 kg	approx. 16 kg	approx. 11 kg

Technical specifications	
Input voltage	180 V - 300 V (230 V)
Input frequency	50 Hz (40 Hz - 70 Hz)
Input current	16 A
Output voltage	8 V - 48 V
Max. output current	110 A
Output power	2.800 W (3.600 VA) at 80 % duty cycle
Temperature range	- 20 ˚... +60 ˚C
Safety certificates	IP 54, CE, GS (TÜV Product Service)
Dimensions in mm (LxWxH)	236 x 295 x 330

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Accessories for HST 300 Electrofusion Welding Machines

Replacement Bar-Code Scanning Wand
Complete with plug.

Item-No.: 42264

Aluminum Storage Box
For one HST 300 machine.

L x B x H: 390 x 290 x 340 cm **Item-No.: 70961**

Adaptor Storage Bag

Item-No.: 42263

Push-On Adaptor, round, for elbows

Item-No.: 91166

Push-On Adaptor, flat

Item-No.: 91167

Push-On Adaptor for loose-end fittings

Item-No.: 91168

Push-On Adaptor for safety fittings

Item-No.: 42261

See pages 5E-39/40 for VIETZ peeling and surface scraping tools.

You can find power generators for VIETZ Electrofusion Welding Machines in Part 3E, starting with page 52.

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Accessories for data logging and documentation of HST 300 series

DataWork (software)

Data logging and documentation as well as process traceability are crucial elements for safe and reliable welding of thermoplastic pipes. In this respect, the machines of the HST 300 series offer a multitude of possibilities. Welding-data log files can easily be transfered from the welding machine or a pocket PC to the DataWork software application. DataWork administers, archives and converts the welding data and transfers them to all common databases. DataWork complies with regulations for extended data logging and documentation according to ISO TC 138 SC 4.

DataWork (WIN 95/98/2000/NT/XP software)

Software package to transfer and process welding-data log files.

Item-No.: 42256

Features and functions

- transfer and editing of welding-data log files
- comprehensive filing functions (by report header data, welding data, fitting data, traceability data), incl. nested filing
- linking of GPS data and weld seam identification
- data conversion and transfer to various Windows applications (Excel, Word)
- data highlighting and printing out of log files
- multi-lingual user interface
- log-file transfer via e-mail

DataTrans (WIN CE software)

By means of DataTrans, log files can be transfered to a pocket PC over USB or wireless Bluetooth interface. The log files can be displayed by the pocket PC and, if requested, transfered to the DataWork application for further editing.

Item-No.: 42255

Pocket PC

The ideal partner for DataTrans! The pocket PC administers and files all data and communicates over serial USB or wireless Bluetooth interface. It thereby offers users great support with regard to pre-filing large amounts of welding data occuring in large data networks.

Item-No.: 42255P

Serial Adaptor

Serial cable with adaptor to read out data. Can be used with all machines of the HST 300 series.

Item-No.: 42255S

Bluetooth Adaptor

Bluetooth adaptor to read out data. Can be used with all machines of the HST 300 series.

Item-No.: 42255B

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VIETZ Hand-Held Hot-Air Welding Torch

Lightweight Hand-Held Hot-Air Welding Torch for welding thermoplastics

- for welding all kinds of thermoplastics
- for soldering/brazing pipes and fittings
- for bending and shrinking

Lightweight, high-performance hot-air welding torch. Equipped with a small and user-friendly handlepiece. Allows professional and fatigue-free welding. Also features a cold setting without heating preset adjustment. Commutator brushes can be replaced several times, enabling continuous tool use. Brush replacement can be done easily from the outside without need to open up the device. Air-cooled heating element fits a number of different nozzle forms.

One nozzle of your choice included!

Technical specifications

Voltage:	230 V 50/60 Hz or 120 V 50/60 Hz
Heating capacity:	1500 W / 230 V or 1300 W / 120 V
Temperature range:	20 - 700 °C, infinitely variable
Weight:	1200 g, incl. 3-m power-supply cable

Item-No.: 42040

High-speed nozzles available on request.

VIETZ Hand-Held Extrusion Welder

For welding thermoplastics

Welding plastics today is as common as welding metals. Hot-gas extrusion welding is a semi-mechanical process used to weld with films and foils or to weld thick-walled thermoplastic workpieces.

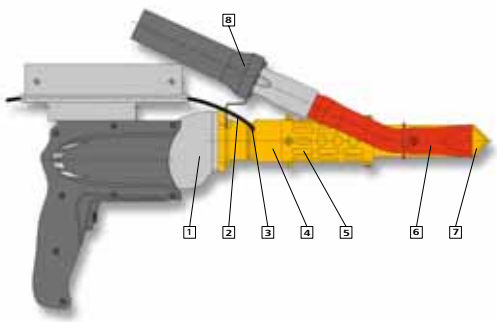
Depending on the weld-seam thickness and the welding material used, the welder has to set the ejection quantity, the preheating temperature and the temperature of the welding material. The shape and size of the weld seam is determined by the welding speed and the contact pressure the welding shoe exerts on the parts to be joined.

In order to achieve optimal welding results, we recommend to follow the guidelines of the German DVS authorities or to attend an adequate training course.

info

Operating principle of an extrusion welder

Driven by an electric motor (1), the welding rod (2) is led into the extruder (4) over a feeder (3). The extruder screw granulates the rod and pushes it into the melting chamber (5), where it is melted in order to be ejected from the device's nozzle.
In parallel, hot air is expelled from the preheating nozzle (6) to heat the substrate material. The molten filler material is ejected onto the heated substrate material, and the welding shoe (7) forms the weld seam. The hot-air unit (8) is supplied over an external compressor or an integrated blower.



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VIETZ Hand-Held Extrusion Welder

EVX-18-S-B 1) 2)

EVX-25-B 1) 2)

EVX-40-B

EVX-65-B

VIETZ Hand-Held Extrusion Welder with integrated blower

Used in workshops and on construction sites.
The integrated hot-air blower provides independence of external systems

Advantages:

- very long service life due to innovative drive technology
- exact temperature control due to individually selectable wire thickness and materials
- motor-starting protection prevents the device from being cold-started
- impact-resistant temperature sensors for measuring preheating temperature and filler-material temperature

1 welding shoe and 1 set of nozzles included!

Type	EVX-18-S-B 1) 2)	EVX-25-B 1) 2)	EVX-40-B	EVX-65-B
Item-No.:	45100	45101	45102	45103
Max. welding capacity	1,8 kg/h, Ø 4 mm 1,1 kg/h, Ø 3 mm	2,5 kg/h, Ø 4 mm 1,4 kg/h, Ø 3 mm	3,9 kg/h, Ø 5 mm 2,5 kg/h, Ø 4 mm	6,5 kg/h, Ø 5 mm 4 kg/h, Ø 4 mm
Applicable for	PP / PE / PVDF	PP / PE / PVDF	PP / PE / PVDF	PP / PE / PVDF
Filler material	plastic cord rod Ø 3 / 4 mm	plastic cord rod Ø 3 / 4 mm	plastic cord rod Ø 4 / 5 mm	plastic cord rod Ø 4 / 5 mm
Workpiece thickness	wall thickness 4 – 15 mm foils/films > 1 mm	wall thickness 4 – 15 mm foils/films > 1 mm	wall thickness 8 – 30 mm foils/films > 1 mm	wall thickness 12 – 40 mm foils/films > 1 mm
Weight	4,8 kg	6 kg	8 kg	9,4 kg
DVS conformity		•	•	•
Length	455 mm	470 mm	570 mm	700 mm
Electronic speed control	•	•	•	•
Drive	brush-type	brushless	brushless	brushless
Power box required	-	•	•	•
Heating band	-	400 W	650 W	800 W
Hot-air blower	2000 W	2200 W	2200 W	2200 W
Voltage	230 V and 120 V	230 V	230 V	230 V

1) Supporting stand included - 2) Special 45° and 90° heads and extension pieces available

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Accessories for VIETZ Hand-Held Extrusion Welder

VIETZ Power Box

Contains the frequency inverter with EMC filter and the complete power supply unit for brushless VIETZ extrusion welders.

Item-No.: 45105

Storage Case

For safe storage and transportation of VIETZ extrusion welder.

Size	For models EVX	Dimensions (LxWxH)	Item-No.:
1	18-S-B / 25-B / 40-B	700 x 580 x 350 mm	45106
2	65-B	1000 x 580 x 380 mm	45107

Rod Unwinder

For two rod spools up to 10 kg each. 360° rotatable. Easy to dismantle for transportation.

Item-No.: 45109

Weld-Seam Cutter

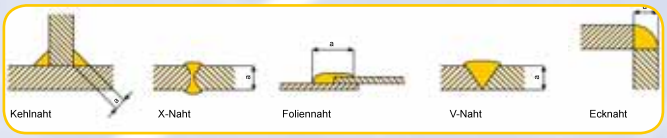
To process overlapping weld seams without damaging the base material.

Item-No.: 45110

See part 1E, page 39 for digital thermometers to verify the hot-gas temperature and the filler-material temperature (according to DVS guideline 2207-4).

EVX welding shoes

To achieve excellent welding results, the welding shoe must fit the respective geometrical properties of the weld seam.



We manufacture and supply EVX welding shoes tailor-made to your individual requirements. More information on request.

Information on hand-held extrusion welders with external air supply on request!

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VIETZ Plastic-Pipe Cutters

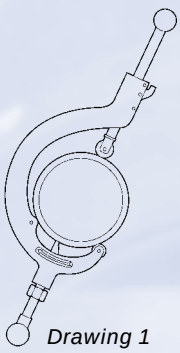
Plastic-Pipe Cutter PREMIUM

This rugged pipe cutter is equipped with a cutting wheel that allows to cut small, medium and large-sized PE pipes. The cutter's design ensures excellent handling and precise cutting. The cutting wheel can be exchanged within a few seconds without need of tools.

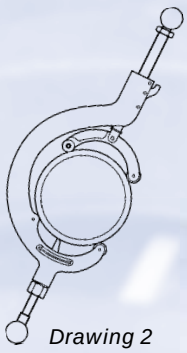
Type	For pipe diameter	Length	Weight	Cutting wheel supplied	Item-No.:
TC 1 QP	3 - 33 mm	152 mm	0,3 kg	OP2	**42133**
TC 2 QP	6 - 63 mm	203 mm	0,5 kg	OP2	**42134**
TC 3 QP	10 - 90 mm	279 mm	1,1 kg	6QP	**42135**
TC 4 QP	48 - 114 mm	305 mm	1,3 kg	6QP	**42136**
TC 5 QP	63 - 125 mm	330 mm	1,4 kg	6QP	**42137**
TC 6 QP	102 - 168 mm	381 mm	1,8 kg	6QP	**42138**

Replacement Cutting Wheels

Type	For pipe cutter	Application	Cutting depth	Qty.	Item-No.:
OP2	TC1QP, TC2QP	ABS, PE, PEX, PP, PEX/AL/PEX	7,0 mm	12	**42126**
1-2PVC	TC1QP, TC2QP	PVC, CPVC	7,1 mm	12	**40475**
30-40P	TC3QP, TC4QP TC5QP, TC6QP	ABS, PE, PP	8,7 mm	12	**42127**
3-6PVC	TC3QP, TC4QP TC5QP, TC6QP	Thick PVC, CPVC	9,6 mm	12	**42128**
6QP	TC3QP, TC4QP, TC5QP, TC6QP, TC8QP	Thick PE	14,0 mm	4	**40430**
80P	TC6QP, TC8QP	ABS, PE, PP	19,1 mm	4	**42129**



Drawing 1



Drawing 2

Dual Plastic-Pipe Cutter TC 8 QP PREMIUM

This cutter uses a cutting wheel for pipe walls up to 17,5 mm thickness (drawing 1), and a cutting blade plus cradle for pipe walls thicker than 17,5 mm (drawing 2), so that excellent handling and precise cutting is possible also for larger pipe dimensions. Cutting wheel, cutting blade and cradle included.

For pipe diameter: 159 -254 mm
Cutting wheel supplied: 80P **Item-No.: 42139**

Replacement Cutting Blade

forTC 8 QP **Item-No.: 73020**

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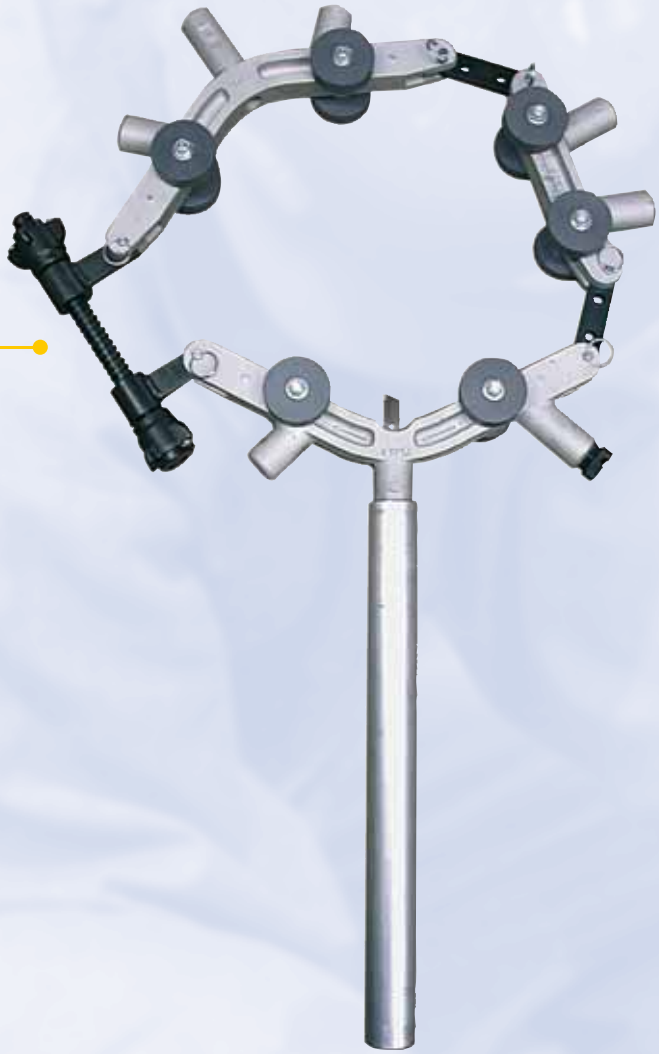
VIETZ Plastic-Pipe Cutters

Plastic-Pipe Cutter PLAS
to cut plastic pipes OD 110 - OD 800

The modular concept makes this cutter ideal for cutting plastic pipes in the ditch, requiring only 15 – 20 cm clearance around the pipe. Outboard rollers keep the cutter aligned on the pipe to ensure a square cut. Long-lasting, carbide-tipped blades penetrate up to 50 mm wall thickness. Moreover, the cutter can simultaneously produce a 15° bevel on both sides of the cut.

Type	For pipe	Modules required	Item-No.:
PLAS 0	Ø 110-240 mm	A, C	40456
PLAS 1	Ø 160-335 mm	A, B, C	40457
PLAS 2	Ø 355-500 mm	B, C (2x), D	40458
PLAS 3	Ø 355-630 mm	B, C (3x), D	40459
PLAS 4	Ø 355-800 mm	B, C (4x), D	40460



Replacement Blades

Cutting Blade (PE)	Item-No.: 73028
Beveling Blade (15°)	Item-No.: 73027

Beveling blade for 15° bevel

A

B

C

D

Modular concept allows to retrofit the cutter for working with larger pipes!

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VIETZ Plastic-Pipe Cutters

VIETZ Ratchet Shears

Ideal for quickly and precisely cutting plastic pipes. The device offers a 7-step ratchet mechanism for best mechanical advantage and smoothest operation. Extra wide, v-style jaws ensure excellent alignment of the blade.

Ratchet Shear PREMIUM

For pipe Ø up to 42 mm — Item-No.: 42084
For pipe Ø up to 63 mm — Item-No.: 42085

Replacement Blades

For pipe Ø up to 42 mm — Item-No.: 42086
For pipe Ø up to 63 mm — Item-No.: 42087

Ratchet Shear STANDARD

For pipe Ø up to 42 mm — Item-No.: 42077
For pipe Ø up to 60 mm — Item-No.: 42078

Replacement Blades

For pipe Ø up to 42 mm — Item-No.: 42079
For pipe Ø up to 60 mm — Item-No.: 42080

Plastic-Pipe Saws

Ideal for simple and quick cutting of plastic pipes.
(No guarantee for square cuts.)

Type	Recommended for pipe Ø up to	Length	Item-No.:
PREMIUM	100 mm	560 mm	40440
STANDARD	90 mm	500 mm	40440L

PREMIUM

STANDARD

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VIETZ Guillotine PE-Pipe Cutters

VIETZ Guillotine PE-Pipe Cutters

Ideal for quickly and precisely cutting PE pipes. Particularly suitable for being used in confined spaces, as only little clearance is required around the pipe. Allows to cut also out-of-round pipes. Available in two versions.

Guillotine PE-Pipe Cutter with straight blade

Cutter slices through the pipe by means of a Teflon-coated, straight blade.

Size	For pipe diameter	Weight	Item-No.:
1	Ø 63-125 mm	7,7 kg	42058
2	Ø 90-225 mm	13 kg	42059

Replacement Blades (straight)

Size 1	Item-No.: 73024
Size 2	Item-No.: 73016

Guillotine PE-Pipe Cutter with tapered blade

Cutter slices through the pipe by means of a Teflon-coated, tapered blade. Particularly suitable for cutting thin-walled pipes.

Size	For pipe diameter	Weight	Item-No.:
1	Ø 0-125 mm	7 kg	42058V
2	Ø 0-225 mm	17 kg	42059V
3	Ø 0-323,8 mm	33 kg	42090V

Replacement Blades (tapered)

Size 1	Item-No.: 73024V
Size 2	Item-No.: 73016V
Size 3	Item-No.: 73028V

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VIETZ Plastic-Cutting Circular Saws

VIETZ Circumferential Circular Saw UKS 160-355

This device is ideal for easily making well-repeatable square cuts on PVC, PE and PP pipes with a diameter ranging from 160 to 355 mm and a minimum wall thickness of 8 mm.

Rubber guiding rollers allow accurate square cuts without edge misalignment. Perfect handling of the tool is ensured in no time at all. The cutting depth fine adjustment provides for well-repeatable cuts and high time savings. Working safety is ensured by a central clamping mechanism and a saw blade protection.

For pipe diameter: Ø 160 – 355 mm
Motor: 230 V
Weight: 18 kg (saw) + 14 kg (case)
Included in supply: Saw blade and transport case

Item-No.: 42720

Advantages at a glance:

- Cutting depth fine adjustment
- Perfect pipe alignment through central clamping mechanism
- Broad rubber rollers for tool clamping and tool guiding
- Saw blade protection

Replacement Saw Blade

Item-No.: 42720S

Other versions are available on request!

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VIETZ PE Welding Accessories

PE-Pipe Cleaner

Used to clean PE pipes before welding.
Qty. = 6 bottles

1 bottle = 1000 ml **Item-No.: 42065**

PE-Pipe Marker

Used to mark and label PE pipes and fittings. Also used to make color markings on PE pipes before peeling, in order to make sure the peeling process will be done accurately.
Qty. = 6 markers

Silver **Item-No.: 42082**
Black **Item-No.: 42089**

PE-Pipe Heater

Used to carefully heat PE pipes at low ambient temperatures (lower than 10 ˚C) up to approx. 20 °C before welding or squeezing off, in order to minimize temperature-related tensions and avoid material damage.

Temperature: 20 ˚C - 650 ˚C
infinitely variable, with cold setting
Output power: 3000 W **Item-No.: 42039**

See part 1E, page 37 for temperature measuring devices.

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VIETZ PE-Pipe Surface Scrapers and Peelers

PE-Pipe Surface Scraper

Hand-held device with four-side blade to scrape the oxide skin off PE pipes.

Item-No.: 42088

Replacement Blade

4-sided **Item-No.: 42081**

PE-Pipe Peeler

Hand-held device for removal of the outer coating of pipe ends to the depth required for attaching the respective fittings and for fitting saddle pieces or tapping saddles.
When removing the outer coating from SLA®- and SLM® pipes, it is crucial that the cutting process does not damage the pipe core. VIETZ PE Pipe Peelers meet this important requirement, as the cutting depth can exactly be adjusted between 0 and 5 mm.
Storage case included.

For core pipe diameter 25 - 160 mm **Item-No.: 42215**

Replacement Blade

For PE Pipe Peeler **Item-No.: 42216**

Blade Holder

For PE Pipe Peeler **Item-No.: 42217**

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VIETZ Plastic-Pipe Beveler

Plastic-Pipe Beveler

This rugged and handy device features a strong aluminum alloy frame and effective roller locking for long service life. A smooth 15° bevel can be produced on all types of plastic pipe in about one minute. The device is easily adjustable for different pipe sizes and thicknesses without need to exchange any parts.

This device is recommended for butt welding to avoid a high beaded rim on the weld seam. It is also ideal for electrofusion welding to produce a pipe bevel for better fit of the pipe into the sleeve.

Size	For pipe diameter	Weight	Item-No.:
1	1 ½“ - 8“ / 40 - 200 mm	1,4 kg	**42170**
2	1 ½“ - 12“ / 40 - 300 mm	2,8 kg	**42171**

PE-Pipe Beveling Bell
to quickly bevel PE pipes OD 20 - OD 63 mm

When using compression fittings, we recommend to bevel PE pipes by means of a beveling bell, in order to avoid damage of the sealing ring.

Pipe diameter: OD 20 - OD 63 mm **Item-No.: 42205**

Replacement Blade

For PE Pipe Beveling Bell **Item-No.: 42206**

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VIETZ Rotary Surface Scraping Tools for pipe-end preparation prior to electrofusion welding

Rotary Surface Scraper DELUXE

For removal of the outer surface of PE HD pipes prior to joining with electrofusion couplers.

Easy and comfortable to use. The spring-tensioned blade and the automatic advance provide for continuous adaptation to pipe unroundings and tolerances, allowing an even scraping process. The top-quality carbide cutting blade offers long service life

	Size 1	Size 2
Item-No.:	41810	41811
For pipe Ø	OD 32 to OD 110	OD 110 to OD 500
Scraping width	80 mm	145 mm
Weight	2,2 kg	5,3 kg
Storage case (included)		
Dimensions (LxWxH)	360x150x290 mm	400x195x350 mm
Weight	2,6 kg	3,9 kg

Replacement Blade

For VIETZ Rotary Surface Scraper DELUXE, size 1 and 2

Item-No.: 41812

Rotary Surface Scraper STANDARD

For removal of the outer surface of PE HD pipes prior to joining with electrofusion couplers.

Each pipe diameter requires a separate scraper.
The spring-tensioned blade and the automatic advance provide for continuous adaptation to pipe unroundings and tolerances, allowing an even scraping process. The top-quality 4-side carbide cutting blade offers long service life.
The tool's plastic handlepiece serves as a storage box for the replacement blades.

	Size 1	Size 2	Size 3	Size 4
Item-No.:	41779C	42635	42636	42140C
For pipe Ø	OD 32	OD 40	OD 50	OD 63
Scraping width	50 mm	70 mm	70 mm	70 mm
Weight	0,2 kg	0,3 kg	0,4 kg	0,5 kg

Replacement Blade

For VIETZ Rotary Surface Scraper STANDARD, size 1, 2, 3 and 4

Item-No.: 41779M

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VIETZ Rotary Peeler
for pipe preparation prior to electrofusion welding

VIETZ Rotary Peeler - For pipe-end peeling and preparation of electrofusion couplings, tees and elbows

The peeler is opened, placed around the pipe and locked. A special mechanism allows to attach the rotary peeler to any position of the pipe, so that the device can be universally applied. A special mechanical advance system ensures an even peeling process.

For consistent peeling at only little exertion of force!

Size	Item-No.:
OD 32	42630
OD 40	42631
OD 50	42632
OD 63	42633
OD 90	42638
OD 110	42639

Replacement Blades

For rotary peeler OD 32 and OD 40	Item-No.: 42634
For rotary peeler OD 50 and OD 63	Item-No.: 42637
For rotary peeler OD 90 and OD 110	Item-No.: 42641

Storage Case

To accommodate one VIETZ Rotary Peeler of one of the following sizes:
OD 32 / OD 40 / OD 50 / OD 63
Rotary Peeler not included!

Item-No.: 42640

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VIETZ Internal Bead Trimmer

VIETZ Internal Bead Trimmer

for inside pipe diameter 110 – 400 mm

To remove the internal weld bead of PE and PP pipes formed during the fusion welding process.

Included in supply:

- storage and transport case
- reach rod set of 12 meters max. length incl. turning handle
- cutting heads No. 1, 2, 3 and 4

Each cutting head can be used in four positions, allowing to process any pipe dimension and wall thickness.

Item-No.: 42706F

info

Butt-welded pipelines made from thermoplastics are ideal for a multitude of applications. However, there is always the problem of inner weld beads formed during the fusion welding process. Inner weld beads reduce the pipe diameter at every bead location, resulting in reduced pressure in case of gas pipelines or reduced flow rates in case of pipelines carrying fluid media. There is also the danger of mud and particles accumulation occuring on inside weld beads. In long pipelines, this reduction in diameter occuring at every pipe joint results in a cumulative counterpressure, which strongly reduces flow rates.

Replacement Blade

For cutting heads 1 + 2	Item-No.: 42706A
For cutting heads 3 + 4	Item-No.: 42706B

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VIETZ External Bead Trimmer

VIETZ External Bead Trimmer

To remove the external weld bead of PE and PP pipes formed during the fusion welding process.

- easy to use
- easy adjustment to pipe dimension
- no damage to pipes
- specially tempered blade
- incl. storage case

Working range	Item-No.:
90 – 125 mm	42708
75 – 400 mm	42709
400 – 800 mm	42710

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VIETZ PE-Pipe Holding Clamps

VIETZ PE-Pipe Holding Clamps

These clamps are used in electrofusion welding to position and align PE pipes. They protect pipe joints from all directional movements during welding and cooling. This is an important point in order to meet requirements concerning tension-free installation of PE pipes.

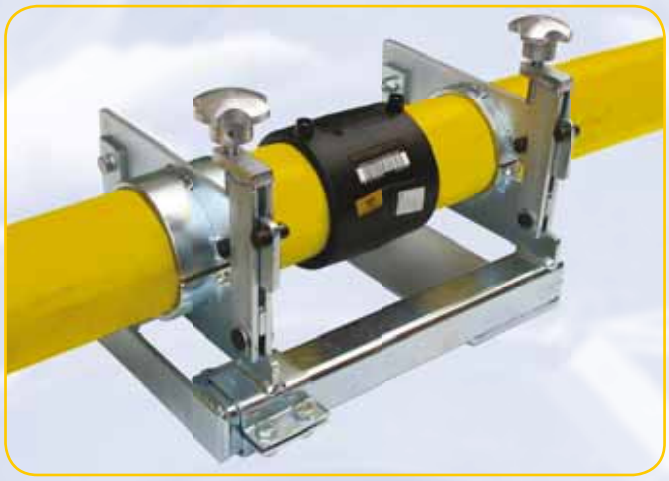
VIETZ PE Pipe Holding Clamps are available in various versions and sizes, depending on your specific application.

Double Clamp

with set-screw to adjust pipe ends
for pipes OD 32 – OD 63

Particularly suitable for the laying of connected pieces, as pipe ends can be adjusted by means of a set-screw, allowing precise pipe alignment.

For pipe diameter	Item-No.:
OD 32	42095
OD 40	42096
OD 50	42097
OD 63	42098

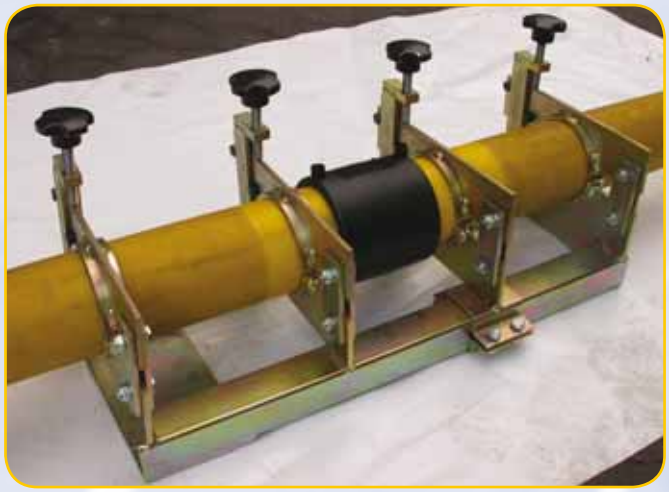


Universal Double Clamp

For all electrofusion couplers available

Particularly suitable for working in very confined spaces due to short-length design. Allows to weld couplers of all manufacturers, as one of the clamping jaws is infinitely variable along the pipe's axis.

For pipe diameter	Item-No.:
OD 75	42743
OD 90	42099
OD 110	42100
OD 125	42101
OD 140	42744
OD 160	42102
OD 180	42745
OD 200	42746
OD 225	42103



Universal Quadruple Clamp

For all electrofusion couplers available

Equipped with four clamping elements for excellent stability and alignment. Particularly suitable for difficult installation tasks involving high tension. Allows to weld couplers of all manufacturers, as one of the inner clamping jaws is infinitely variable along the pipe's axis.

For pipe diameter	Item-No.:
OD 75	42747
OD 90	42450
OD 110	42451
OD 125	42452
OD 140	42748
OD 160	42453
OD 180	42454
OD 200	42749
OD 225	42455

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VIETZ Universal Positioning Kit, angle-adjustable and dimension-variable

Reduction pieces

Tees

VIETZ Universal Positioning Kit

The VIETZ Universal Positioning Kit is available in two sizes and allows for highest flexibility in electrofusion joining.
By means of this device, all fittings and sleeves incl. angular and reduction pieces available on the market can be welded. An extension kit allows to weld tees.
Two dimension-variable clamps, each one of them infinitely variable along the pipe's axis, can be individually adjusted to the respective pipe dimension. Angle adjustment is possible in 15° intervals between 15° and 90°.

Angle adjustment

Universal Positioning Kit OD 20 - 63

Item-No.: 42750

Adaptor for tees OD 20 - 63 (option)

For VIETZ Universal Positioning Kit.

Item-No.: 42750T

Universal Positioning Kit OD 63 - 180

Item-No.: 42751

Adaptor for tees OD 63 - 180 (option)

For VIETZ Universal Positioning Kit.

Item-No.: 42751T

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VIETZ PE-Pipe Squeeze-Off Tools and Re-Rounding Shells for flow control or temporary closure of pipes

PE-Pipe Squeeze-Off Tool (mechanical) OD 32 – OD 63

To be operated manually by means of a spindle. Damage to pipe caused by squeezing process is minimized by means of adjustable stop plates on the sides.

To squeeze off pipes OD 32 to OD 63

Item-No.: 41800

PE-Pipe Squeeze-Off Tool (hydraulic) OD 75 – OD 180 and OD 160 – OD 225

This hydraulic-powered squeeze-off tool is available in two sizes. Damage to pipe caused by squeezing process is minimized by means of adjustable stop plates on the sides. The squeezing process can be supported mechanically by means of pressure screws. The device is equipped with retaining springs allowing to quickly bring the hydraulic cylinder into the desired position.

For pipe Ø	Item-No.:
OD 75 to OD 180	41801
OD 160 to OD 225	42125

PE-Pipe Re-Rounding Shells

To be used with the VIETZ Squeeze-Off Tool to re-round PE pipes after squeezing.

For pipe Ø	For VIETZ Squeeze-Off Tool OD 75 - OD 180	For VIETZ Squeeze-Off Tool OD 160 - OD 225
OD 75	Item-No.: 41808	-
OD 90	Item-No.: 41802	-
OD 110	Item-No.: 41803	-
OD 125	Item-No.: 41804	-
OD 140	Item-No.: 41809	-
OD 160	Item-No.: 41805	Item-No.: 41807A
OD 180	Item-No.: 41806	Item-No.: 41807B
OD 200	-	Item-No.: 41807C
OD 225	-	Item-No.: 41807

info

When working at low ambient temperatures <10 °C, it is necessary to heat up PE pipes carefully to approx. 20 °C in the area to be squeezed. **See page 5E-36 for the appropriate heater.** In general, squeezing and re-rounding should be done gently, otherwise the molecular chains in the polyethylene material may be destroyed. However, one should note that squeezing and-re-rounding processes – also when executed in compliance with regulations – always lead to a reduction of the pipe's service life. Therefore, the pipe area subjected to squeezing and re-rounding must always be marked to make sure the same area will not be stressed again when working on the pipe at a later point in time.

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VIETZ PE-Pipe Re-Rounding Tools

PE-Pipe Re-Rounding Pliers

For pipe Ø OD 32 — Item-No.: 42066
For pipe Ø OD 40 — Item-No.: 42067

PE-Pipe Re-Rounding Clamp

For pipe Ø OD 50 — Item-No.: 42068
For pipe Ø OD 63 — Item-No.: 42069

PE-Pipe Re-Rounding Clamp (mechanical)

To re-round PE pipes
after squeezing.

For pipe Ø	Type	Item-No.:
OD 63	hinged-collar	42762
OD 75	hinged-collar	42763
OD 90	hinged-collar	42764
OD 110	hinged-collar	42765
OD 125	hinged-collar	42766
OD 140	hinged-collar	42767
OD 160	hinged-collar	42768
OD 180	hinged-collar	42769
OD 200	split-collar	42770
OD 225	split-collar	42771
OD 250	split-collar	42772

PE-Pipe Re-Rounding Clamp (hydraulic)

Re-Rounding Clamp for OD 110 — Item-No.: 42800

Shell insert
for adaptation to other diameters

for Ø 32 mm	Item-No.: 42801
for Ø 40 mm	Item-No.: 42802
for Ø 50 mm	Item-No.: 42803
for Ø 63 mm	Item-No.: 42804
for Ø 75 mm	Item-No.: 42805
for Ø 90 mm	Item-No.: 42806

Re-Rounding Clamp for OD 160 — Item-No.: 42810

Shell insert

for adaptation to other diameters	Item-No.: 42811
for Ø 75 mm	Item-No.: 42812
for Ø 90 mm	Item-No.: 42813
for Ø 110 mm	Item-No.: 42814
for Ø 125 mm	Item-No.: 42815

Re-Rounding Clamp for OD 225 — Item-No.: 42820

Shell insert
for adaptation to other diameters

for Ø 180 mm	Item-No.: 42821
for Ø 200 mm	Item-No.: 42822

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VIETZ PE-Pipe Rollers

VIETZ PE-Pipe Rollers

When long pipe strands are welded, it is necessary to put the workpieces on appropriate holders. Using pipe rollers facilitates pipe conveyance and protects pipes from damages. Particularly when applying butt welding, the resistance of pipes when being conveyed can be reduced substantially, i.e. wear and tear of the hydraulic cylinders of the butt welding machine can be reduced substantially

Pipe Roller for OD 100 mm

Very lightweight, ball-bearing pipe roller with conic roll.

For pipe diameter up to 100 mm.
Capacity: 250 kg
Weight: 1,7 kg

Item-No.: 42083

Pipe Roller for OD 300 mm, with base plate

Ball-bearing pipe roller made of galvanized steel with conic roll.

For pipe diameter up to 300 mm.
Capacity: 300 kg
Weight: 4,2 kg

Item-No.: 42305

Pipe Roller Jack for OD 760 mm

Made of galvanized steel. With two ball-bearing rollers.

For pipe diameter 100 - 760 mm.
Capacity: 400 kg
Weight: 9 kg

Item-No.: 42760

Pipe rollers for your individual requirements available!

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